

Work Order ID 110072

December-17-13 9:07:33 AM

110072

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Item ID: D3245-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door Assy **3**
 Start Date: 12/17/13 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/17/13 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 13-12-19 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3245	D								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00				3x			14/01/13
Packaging									
110	Small Fab	0.00							
110									
Small Fab	Memo	0.00				3x			14/01/13
Small Fab	1-Install Studs and Gromets as per Dwg D32453-Bond Gasket using 3M ADHESIVE as per Dwg D3245								
	A/R 3M 1300/1300L ADHESIVE Batch: <u>M127443</u>								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00				3			
Quality Control									

DAS
36
9-89

DAS
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DAS

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9-89

Picklist Print

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Work Order ID: 110072

Parent Item: D3245-043

Parent Item Name: Door Assy

Start Date: 12/17/13

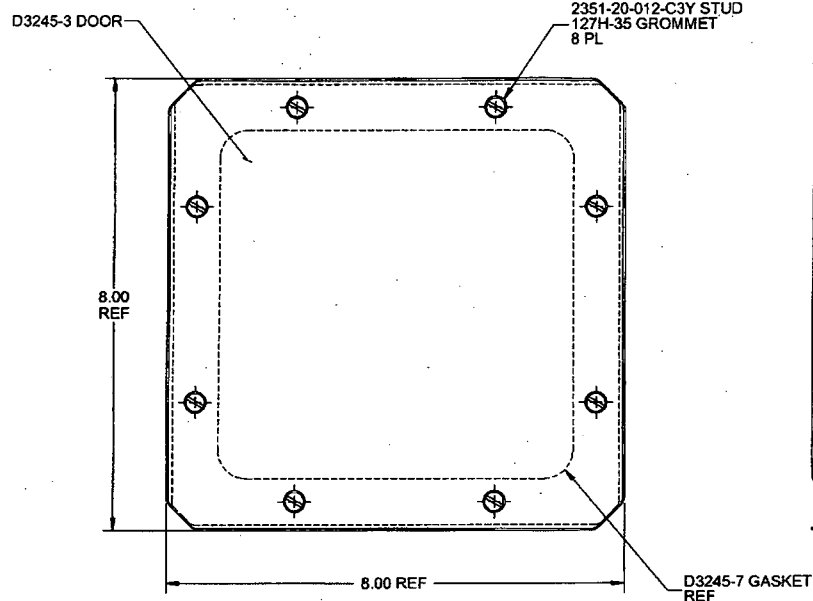
Required Date: 12/17/13

Start Qty: 4.00

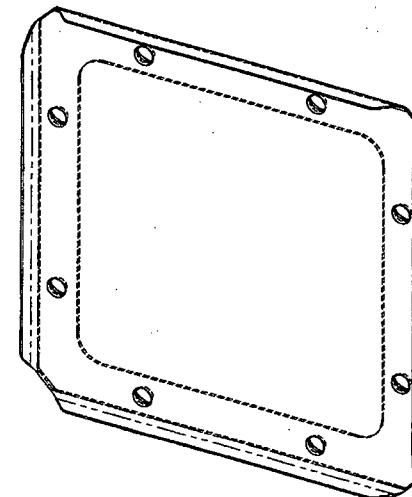
Required Qty: 4.00

Comments: IPP Rev :A New Issue 07-09-11 JLM Verified By:EC
IPP Rev:b ECN 1052 07-10-31 DD verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
127H-35 HALF GROMMET		Purchased	No			100	Each	92.0000	8	32		14/01/13	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		60							
				125288		60			24				
				ST393		32							
				117203		5							
				118261		3							
				119545		16							
				122800		8							
2351-20-012-C3Y STUD		Purchased	No			100	Each	34.0000	8	32		14/01/13	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		33							
				125288		33			24				
				ST396		1							
				122819		1							
D3245-3 Door		Manufactured	No			100	Each	8.0000	1	4		14/01/13	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		8							
				77821		5							
				99438		3			3				
D3245-7 Gasket		Manufactured	No			100	Each	23.0000	1	4		14/01/13	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		8							
				87939		8			3				
				ST233		15							
				86107		15							



INSTALL D3245-7
GASKET ON THIS SIDE
6



D3245-043 DOOR ASSY

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	127H-35	GROMMET
8	2351-20-012-C3Y	STUD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" PER QSI 044 METHOD 6.1
- 9) WEIGHT: 0.74 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3245	REV. D
MFG. APPR.			SHEET 2 OF 7
APPROVED		TITLE ACCESS PANEL ASSY	SCALE NTS
DE APPR.			
DATE	12.10.16	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

110072 MJS
13-12-19

RELEASED
2012-11-06
AND